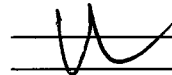
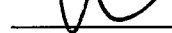


Tuesday, 1/29/2008 8:28:51 AM  
David Duval

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D350-588-041
Job Number	: 37032		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D350588041
This Issue	: 1/29/2008 S.O. No. :	Drawing Number	: RTN283
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: 	Due Date	: 2/5/2008 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

2.0	D350588041	Aft Door Assembly
-----	------------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Aft Door Assembly  
From RTN283. Qty 1 D350-588-041, original B30841

2 chg 003

080129

1

3.0	ENGINEERING 1	ENGINEERING RESOURCE #1
-----	---------------	-------------------------



Comment: ENGINEERING RESOURCE #1

Test fit door on 350 a/c in the lab for fit and function.

080129

①

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

080129

5.0	QC	QUALITY CONTROL
-----	----	-----------------



Comment: QUALITY CONTROL

\*\*\*\* complete work order after test fit \*\*\*\*

See Attached. for continued

Job Completion



instructions

08-02-04

Date: Monday, 04/02/2008 11:50:49 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : D350-588-041
<b>Job Number</b> : 37032	
<b>Estimate Number</b> : 10804	
<b>P.O. Number</b> :	<b>Part Number</b> : D350588041
<b>This Issue</b> : 04/02/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : RTN283
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : 29/01/2008 <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> :
<b>Previous Run</b> : 00015	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/02/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> :	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

2.0	D350588041	Aft Door Assembly
-----	------------	-------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Aft Door Assembly  
From RTN283. Qty 1 D350-588-041, original B30841 @ CHG 003

3.0	ENGINEERING 1	ENGINEERING RESOURCE #1
-----	---------------	-------------------------



**Comment:** ENGINEERING RESOURCE #1  
Test fit door on .350 a/c in the lab for fit and function.

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



**Comment:** INSPECT WORK TO CURRENT STEP

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
- pick the following items to complete the kit:  
- NEW PAPER WORK, AND LABELS REQUIRED @ CHG 003

6.0	AN960JD8	Washer
-----	----------	--------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Washer  
Pick: Kit Picking  
Qty Part Number Description Batch

M106112

JS 08/02/04

(X1)

Date: Monday, 04/02/2008 11:50:49 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-588-041

Job Number: 37032

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16 AN960JD8 Washer

7.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-0811 Screw 104427

AS 08/02/04

(X1)

8.0

MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number Description Batch

10 MS21042L08 Nut (or -08) MB5925

AS 08/02/04

(X4)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Completed (X1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Re-package and stock

location: C

8/2/4 SD

(X4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08-02-05

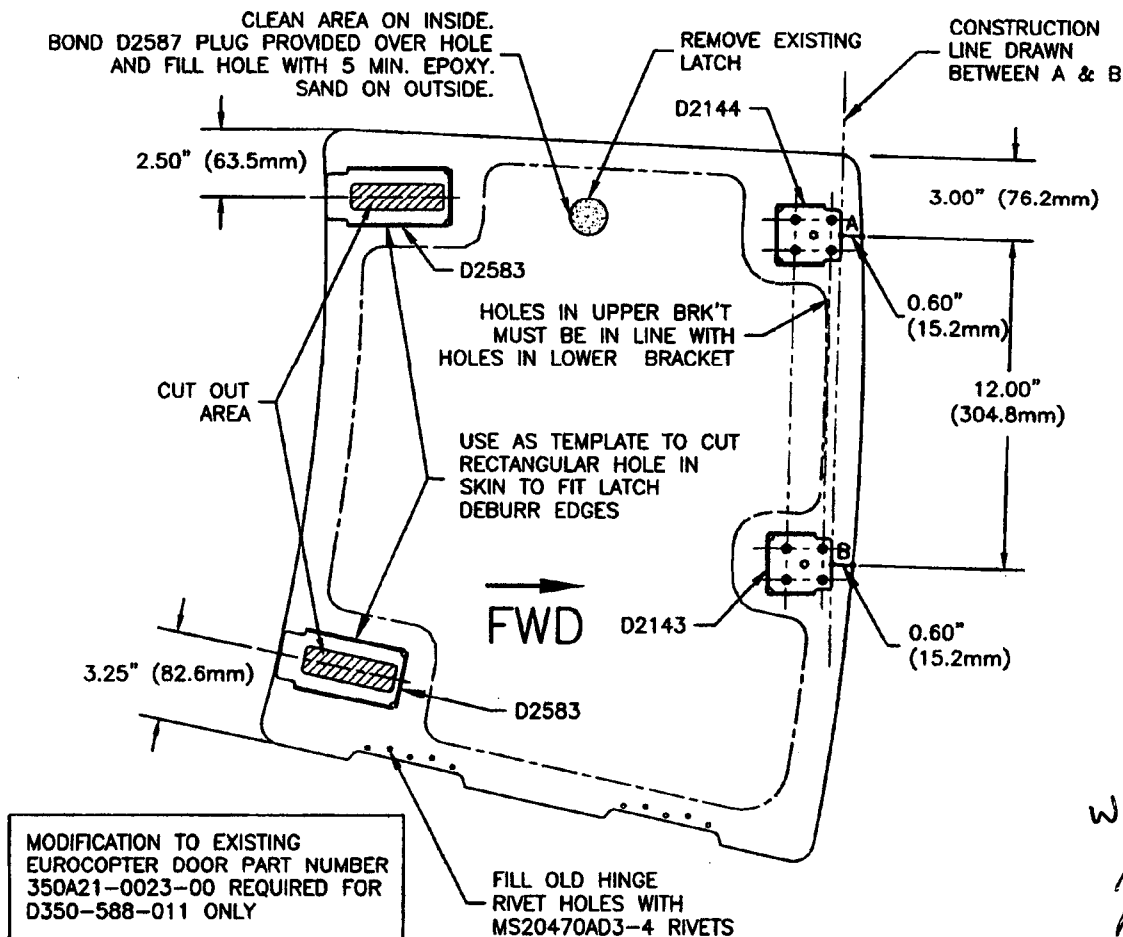


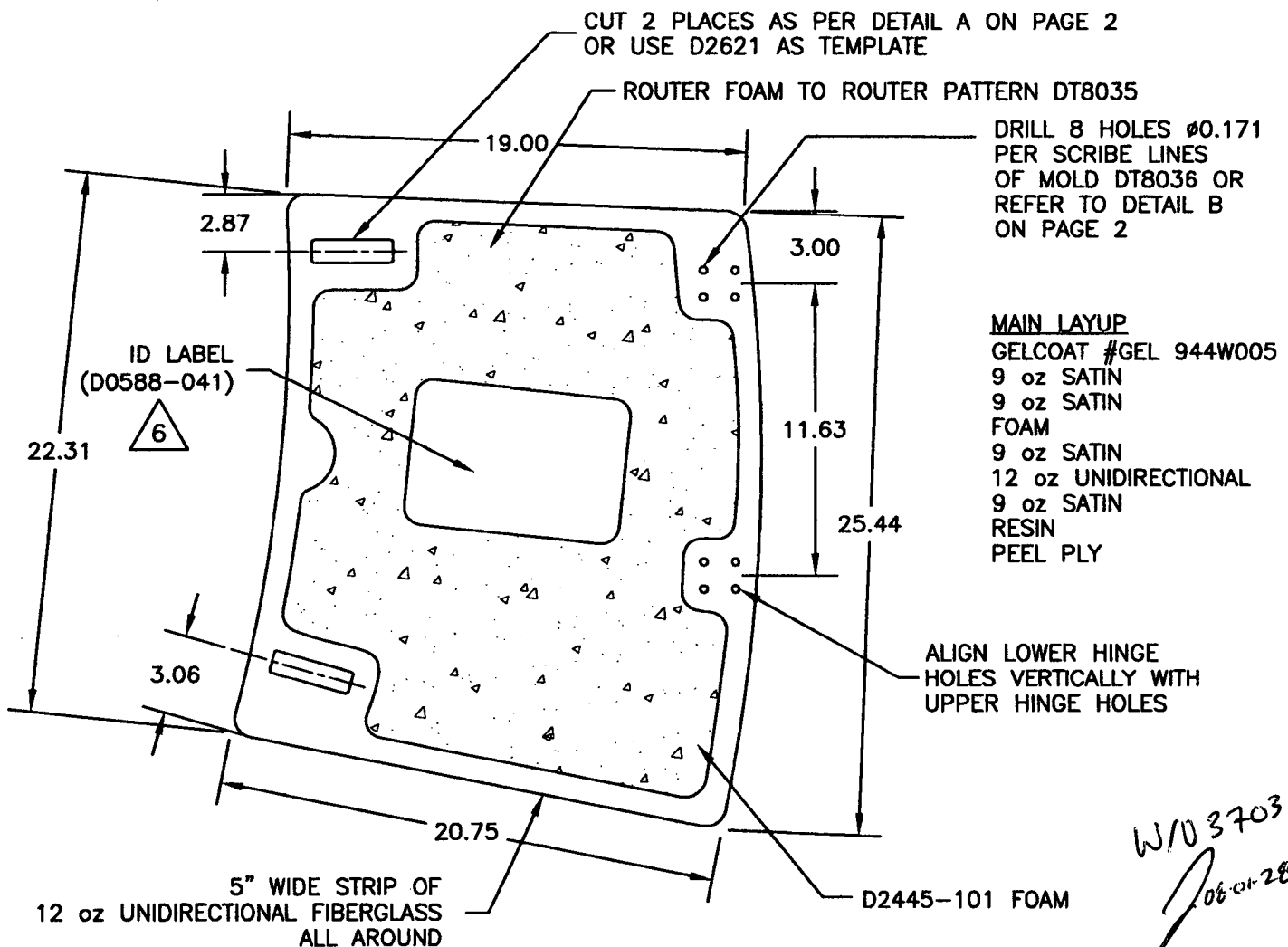
Figure 52-5: Baggage Door Inside View

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52-00-00

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2445</b>	REV. D SHEET 1 OF 2
DATE <b>06.06.09</b>		TITLE <b>AFT BAGGAGE DOOR</b>	SCALE <b>1:7</b>
<b>A</b>	<b>97.07.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>02.01.24</b>	<b>ADD D2621; D2445-101</b>	
<b>C</b>	<b>04.02.09</b>	<b>REMOVE D2621; UPDATE NOTES</b>	
<b>D</b>	<b>06.06.09</b>	<b>ADD DIMENSIONS TO PERIMETER</b>	

**RELEASED**06.11.13 *[Signature]***NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERA KANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 1/17/2008 3:36:40 PM  
 User: Kim Johnston

## Process Sheet

8

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT DOOR ASSEMBLY
Job Number : 36869	
Estimate Number : 12103	
P.O. Number :	Part Number : D350588041
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D2445, D350-588 P5-6
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D,D
Previous Run : 36868	Material :
Written By : <u>                    </u>	Due Date : 2/20/2008 Qty: 1 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est P 04.02.04 Reformat KJ/DS	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-588-041 CHG003

08/01/02

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 5492

C208/01/18 ①

Description: D2445 Baggage Door

Supplier: Delastek

Ship to Delastek (1) D0588-041 label

Certification of Conformity and process sheet from Delastek is required.

3.0	D2445	Aft Door
-----	-------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Aft Door

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure Certificate of Conformity &amp; Process Sheet are attached

P 4/3/2 7 ①

5.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: INSPECT WORK TO CURRENT STEP

Inspect as per Dwg D2445.

- Audit process sheet.

C 08/01/18 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:36:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2143

Bracket Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2143 Hinge Doubler 34969

*[Handwritten signature]*

7.0

D2144

Bracket Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2144 Hinge Doubler 33883

*[Handwritten signature]*

8.0

D2463

1/2" Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene Seal

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2463-0870 1/2" Foam Seal 36852

*[Handwritten signature]*

9.0

D2585

Latch Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2585 Latch Clamp 36026

*[Handwritten signature]*

10.0

D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2586 Latch 36854

*[Handwritten signature]*

11.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

Pick: Assembly Kit

33894

*[Handwritten signature]*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:36:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
2	D2621	Latch Plate	33894

12.0

D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2857-1	Lower Hinge Bracket	36888

Batch

13.0

D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2857-2	Upper Hinge Bracket	33943

Batch

14.0

AN526C832R9

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN526C832R9	Screw	1106918

Batch

15.0

AN960JD8

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	AN960JD8	Washer	1106918

Batch

16.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD10	Washer	1106552

Batch

17.0

MS21042L08

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	MS21042L08	Nut (or -08)	1106903

Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:36:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS21042L3

Nut (or -3)

ml06883

*lu*

19.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 MS27039-1-15 Screw

ml06576

*lu 8/3/27 (1)*

20.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble all of the above parts as per Dwg D350-588

*ml08/04/1*

X1

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*200401 (1)*

22.0

D2150

Packer Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2150

Hinge Packer

36818

*lu*

23.0

D2151

Packer Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2151

Hinge Doubler

36844

*lu 8/4/2 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D2153

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2153

Gas Spring Assy

1336848

25.0

D2154

Bracket, Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2154

Stud Bracket

33886

26.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

Pick: Assembly Kit

Qty

Part Number

Description

Batch

2 D2237

Striker Plate

36847

27.0

D2461

Neoprene "D" Seal



Comment: Qty.: 7.2500 f(s)/Unit Total : 7.2500 f(s)

Neoprene "D" Seal

Pick: Kit Picking

Qty

Part Number

Description

Batch

1 D2461-0870

Neoprene 'D' Seal

34304

28.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2589

Keys, Key Chain

31887

29.0

D28581

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2858-1

Lower Hinge Bracket

1334310

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:36:41 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D28582

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2858-2

Upper Hinge Bracket

36428

*Handwritten signature*

31.0

AN526C832R8

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN526C832R8 Screw

M155516

*Handwritten signature*

32.0

AN526C1032R7

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN526C1032R7

Screw

M124394

*Handwritten signature*

33.0

AN960JD8

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick: Kit Picking

Qty Part Number

Description

Batch

16 AN960JD8

Washer

M107091

*Handwritten signature*

34.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick: Kit Picking

Qty Part Number

Description Batch

2 AN960JD10

Washer

M106552

*Handwritten signature*

35.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 MS20470AD4-5

Rivet

M104156

*Handwritten signature and date 8/4/2 (1)*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:36:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 MS20426AD3-4

Rivet

M105978

37.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3)

M106883

38.0

MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-0811 Screw

M104727

39.0

MS21042L08

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick: Kit Picking

Qty Part Number

Description Batch

10 MS21042L08

Nut (or -08)

M106903

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Rev D

AS

08/04/02

(X1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 1/17/2008 3:36:41 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOOR ASSEMBLY

Job Number: 36869

Part Number: D350588041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/02  
JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-02.

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

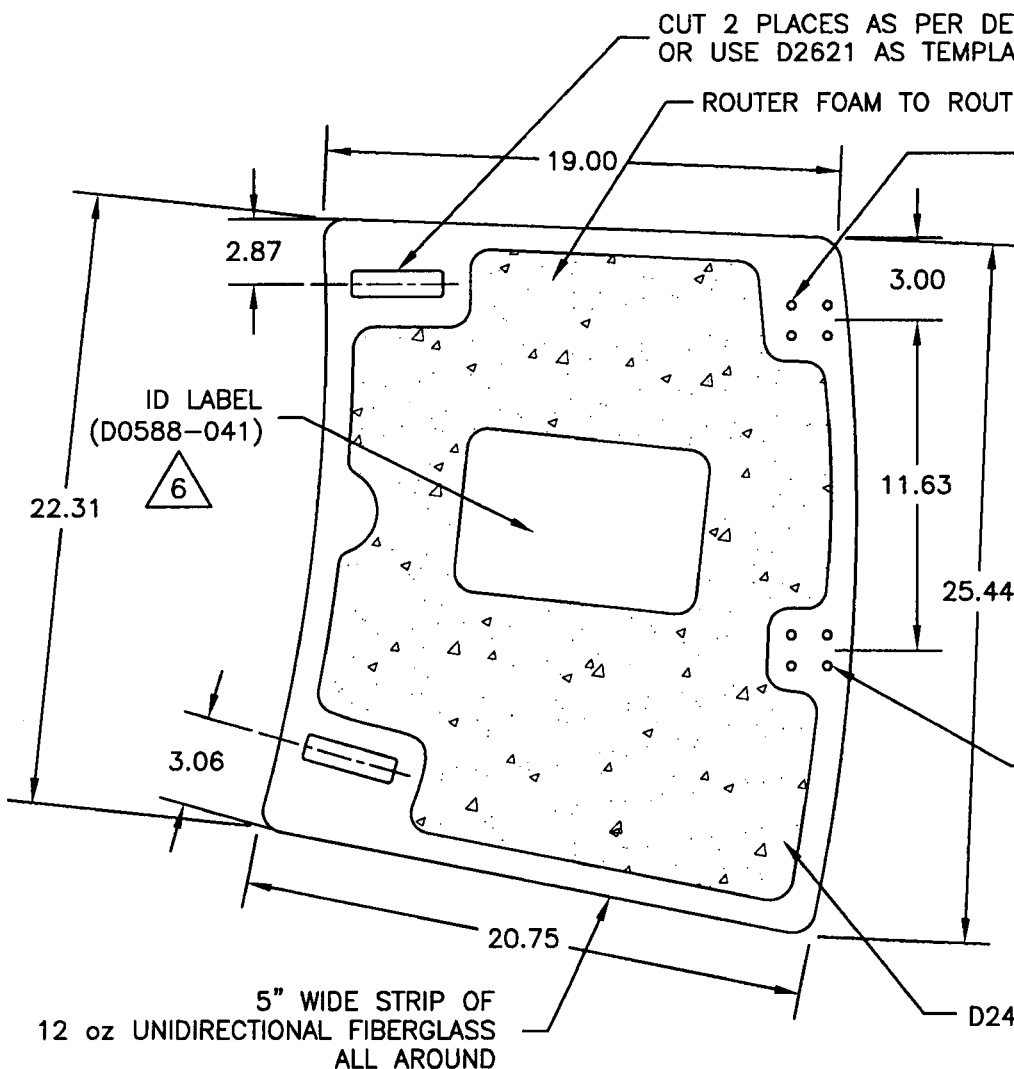
NOTE: Date & initial all entries

**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2445</b>	REV. D SHEET 1 OF 2
DATE <b>06.06.09</b>		TITLE <b>AFT BAGGAGE DOOR</b>	SCALE 1:7
<b>A</b>	<b>97.07.15</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>02.01.24</b>	<b>ADD D2621; D2445-101</b>	
<b>C</b>	<b>04.02.09</b>	<b>REMOVE D2621; UPDATE NOTES</b>	
<b>D</b>	<b>06.06.09</b>	<b>ADD DIMENSIONS TO PERIMETER</b>	

**RELEASED**06.11.13 *[Signature]*CUT 2 PLACES AS PER DETAIL A ON PAGE 2  
OR USE D2621 AS TEMPLATE

ROUTER FOAM TO ROUTER PATTERN DT8035

DRILL 8 HOLES  $\varnothing 0.171$   
PER SCRIBE LINES  
OF MOLD DT8036 OR  
REFER TO DETAIL B  
ON PAGE 2**MAIN LAYUP**GELCOAT #GEL 944W005  
9 oz SATIN  
9 oz SATIN  
FOAM  
9 oz SATIN  
12 oz UNIDIRECTIONAL  
9 oz SATIN  
RESIN  
PEEL PLYALIGN LOWER HINGE  
HOLES VERTICALLY WITH  
UPPER HINGE HOLESD2445-101 FOAM SHOP COPY  
RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICEWORK ORDER  
NO. **36869****NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

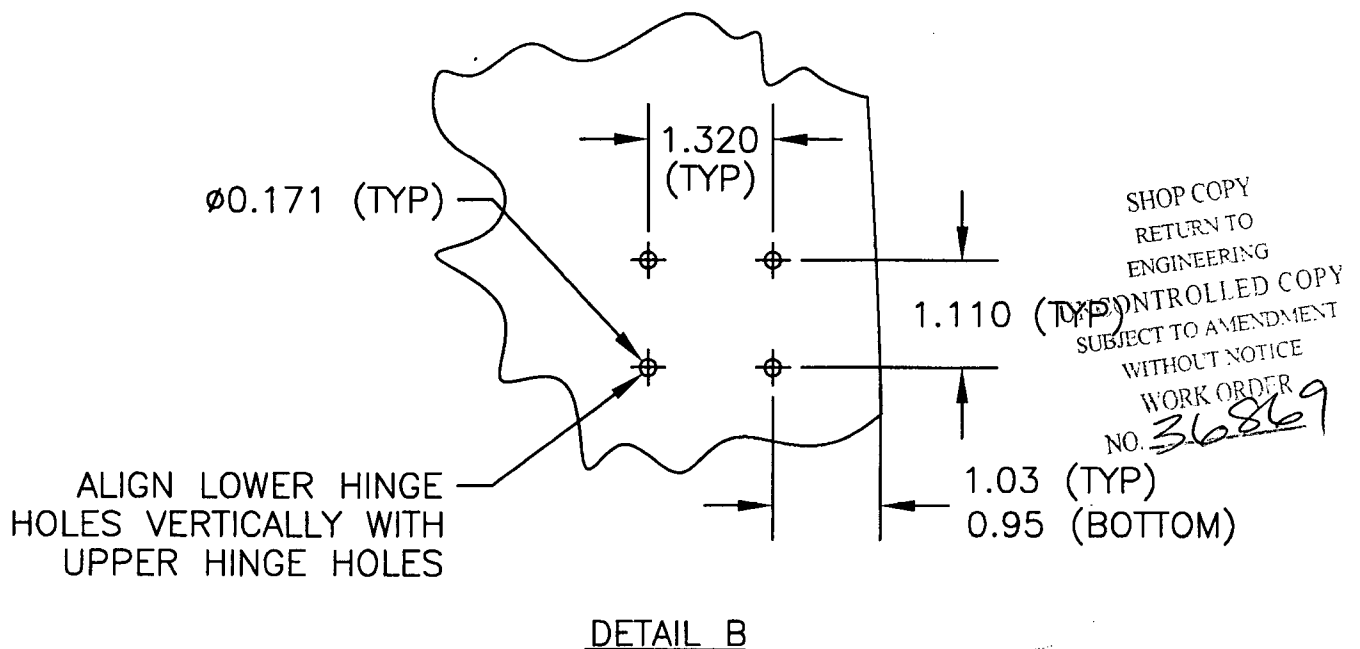
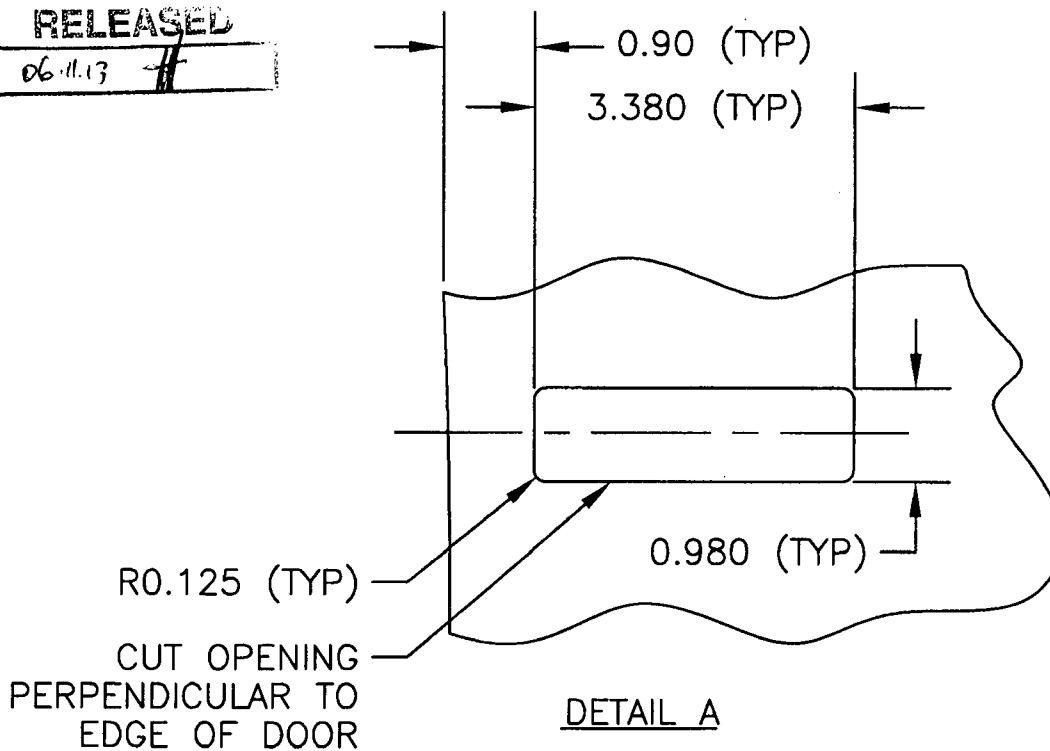
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED  
06.11.13 [Signature]



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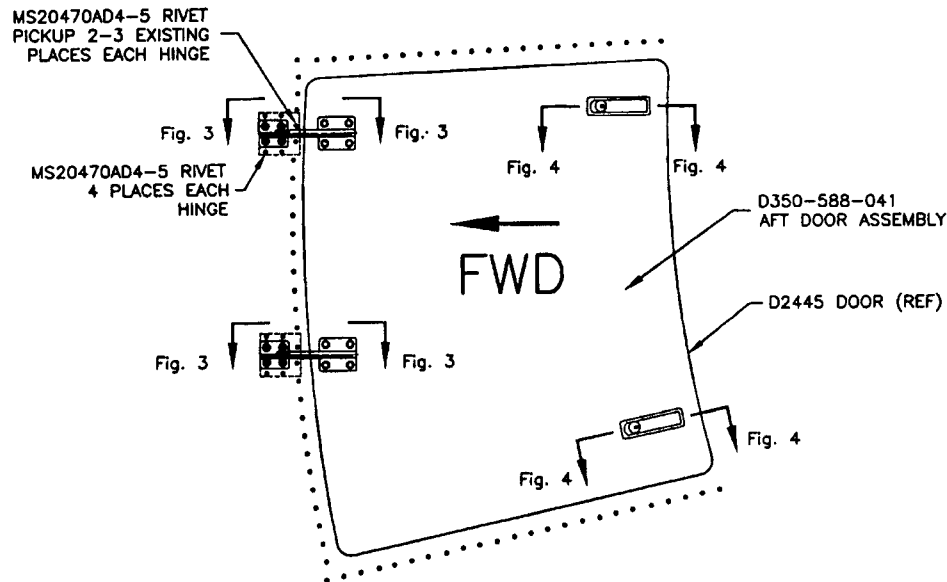


Figure 2: Baggage Door Outside View

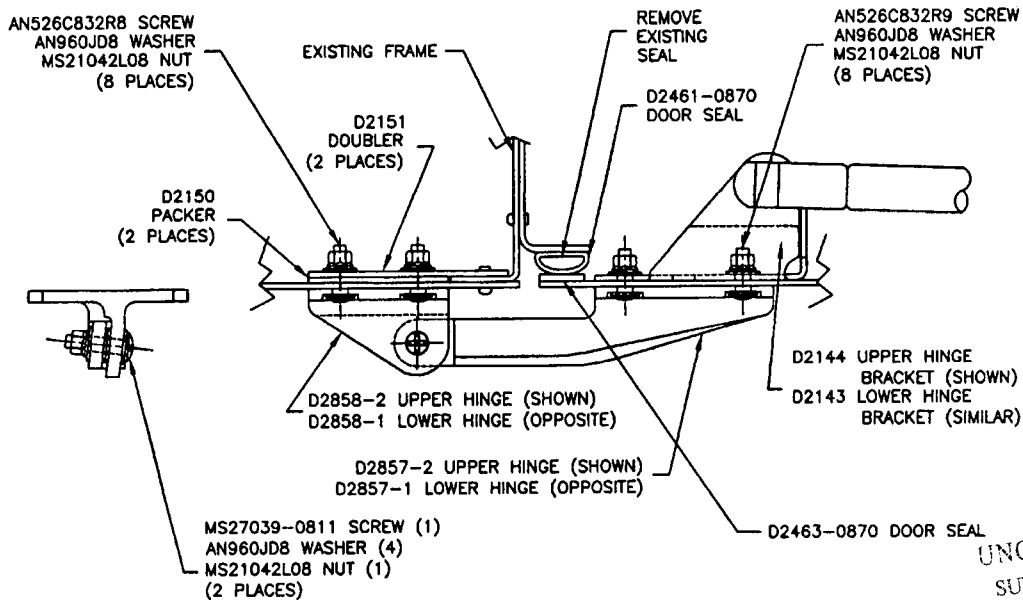
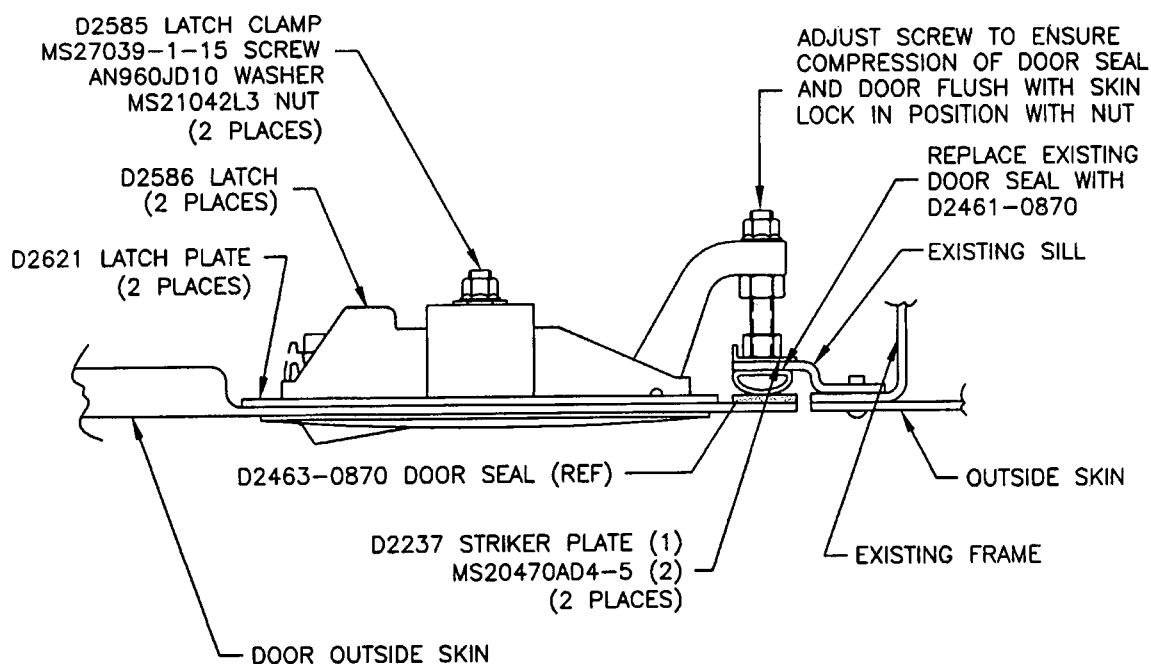


Figure 3: Hinge Detail

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36869





SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36869

Figure 4: Latch Section

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Revision: D  
Date: 02.01.17



DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12532
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:


Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Ship to:

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
25/03/2008	18/01/2008	5649	Chantal Lavoie		PO00005492		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0013	D350-588-041 Aft Baggage Door (D2445) B36869 Drawing N° : D2445 Rév.: D Job: 42579 			
				U de M : Each			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


*Yvan Lessard*  
Quality department AQ-357



Date: Mercredi, 2008-01-23 16:17:30  
 Utilisateur: Marc Dubé

## Feuille de Procédé

<b>Client</b> :	DART Dart Aerospace Ltd.	<b>Nom Dessin</b> :	AFT BAGGAGE DOOR D2445
<b>Numéro Job</b> :	42579	<b>Numéro Article</b> :	DKC134-0013
<b>Numéro Soumission</b> :	2017	<b>Numéro Dessin</b> :	D2445
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DKC134
<b>Cette fois</b> :	2008-01-23 No. B.V. :	<b>Révision dessin</b> :	D
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Fibre 7781 et Résine 411-350
<b>Prm. fois</b> :	-- Type :	<b>Date Dûe</b> :	2008-01-30 Qté: 1 Udm: UNITE
<b>Job précédente</b> :	42578		

Écrit par :   
 Vérifié & Approuvé par :  
 Commentaires : N° de pièce Dart Aérospatiale: D2445  
 N° Delastek Composites: DKC134-0013  
 N° de projet Delastek: DK-362

Process Sheet Rév.: 09 Clarification des opération de mélange et application de primer

## Produit additionnel

Numéro Job:




# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs  
 PRÉPARATION DU MATÉRIEL DART

Faire la préparation du moule N° DT-8036 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 8-03-08 Heure Début: 8:40 Heure Fin: 8:55 Sceau: 

3.0	AAC0273	Gel Coat Blanc N° Gel 944W005
Commentair Qty.: 0.200 GALLON(s)/Unit Total : 0.200 GALLON(s) Gel Coat Blanc N° Gel 944W005		

N° de Lot: 1-6532-1

4.0	AAC0275	Catalyst N° DDM-9
Commentair Qty.: 0.0320 PINTE(s)/Unit Total : 0.0320 PINTE(s) Catalyst N° DDM-9		

N° de Lot: 1-6270-1

Date: Mercredi, 2008-01-23 16:17:30  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

5.0	AC0260	Acetone
-----	--------	---------

Commentaire Qty.: 0.125 KILOGRAMME(s)/Unit Total : 0.125 KILOGRAMME(s)  
Acetone

6.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation du matériel :

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: Jan 23 2008 Sceau: Temps Début: 9:25 Temps Fin: 9:40

7.0	GEL COAT.	APPLICATION DE GEL COAT
-----	-----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
APPLICATION DE GEL COAT

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8036 et laisser sécher pendant un minimum de 12 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. ( Visuel du Gel Coat )

Date: 1-3-08 Sceau: Temps Début: 9:40 Temps Fin: 10:00

8.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentaire Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)  
Tissu à délaminer Release ply B

9.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentaire Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)  
Wrightlon 5200 Bleu P3

10.0	AC0408	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentaire Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)  
Feutre de drainage N° Airweave N 10

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)  
Stretchlon 200 poche à vide Vert

12.0 AAC0326 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)  
9.7 oz 7781 Weave "S" glass #FG-778150-125Y

N° de Lot: 1-6494-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.33 VERGE CAR(s)/Unit Total : 0.33 VERGE CAR(s)  
Fiberglass 12 oz Unidirectional

N° de Lot: 1-6258-1

14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 1.2500 RL(s)/Unit Total : 1.2500 RL(s)  
Ruban à gommer jaune #: T/AT-200Y

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Hrs Total Run : 20.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 28/01/08 Heure Début: 8:00 Heure Fin: 8:30 Sceau: DELA-TER COMPOUTED 32

16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6270-1

Date: Mercredi, 2008-01-23 16:17:30

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 42579

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.359 KILOGRAMME(s)/Unit Total: 0.359 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-19847-1

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11/03/08 Heure Début: 3:15 Heure Fin: 3:20 Sceau:



19.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
LAMINAGE PIÈCE DART

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 11/03/08 Heure Début: 3:20 Heure Fin: 3:35 Sceau:



20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Hrs Total Run : 15.0000Hrs  
FAIRE LA POCHÉ À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre ui suit:

- 1- Tissu à délaminer.
- 2- Film Perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 11/03/08 Heure Début: 3:35 Heure Fin: 3:50 Sceau:



Curing début: 3:20 Curing Fin: 8:00

Date: Mercredi, 2008-01-23 16:17:30  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

21.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0042 PINTE(s)/Unit Total: 0.0042 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6270-1

22.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-19745-2

23.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run: 5.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requise, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core.

Laisser sécher pendant 1 heure.

Date: 23-02-08 Heure Début: 8:50 Heure Fin: 9:05 Sceau:



24.0 AAC0452 Polybond B46F

Commentair Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)  
Polybond B46F

N° de Lot: 1-6324-1

25.0 DKC134-0029 Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D2445-101 ( Pour AFT Baggage Door )

1-19230-2

26.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DART

Retirez le bagging.

Appliquer une couche de polybond B64F à l'endos du foam core N° DKC134-0029 et positionner le foam sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 23-02-08 Heure Début: 2:25 Heure Fin: 2:45 Sceau:



Date: Mercredi, 2008-01-23 16:17:30  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs  
FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Film Perforé P-3.
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200.

Laisser sécher pendant 2 heures minimum.

Date: 1-23-08 Heure Début: 2:45 Heure Fin: 2:55 Sceau:

Curing Début: 2:25 Curing Fin: \_\_\_\_\_

28.0 AAC0275 Catalyst N° DDM-9

Commentaire Qty.: 0.0136 PINTE(s)/Unit Total : 0.0136 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-6270-1

29.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.360 KILOGRAMME(s)/Unit Total : 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-20015-1

30.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 5.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1-3-08 Heure Début: 10:30 Heure Fin: 10:35 Sceau:

31.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
LAMINAGE PIÈCE DART

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes



Date: Mercredi, 2008-01-23 16:17:30

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 42579

Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 14-3-08 Heure Début: 10:35 Heure Fin: 11:05 Sceau:



32.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Hrs Total Run : 10.0000Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer.
- 2- Film perforé P-3.
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200.

Laisser sécher pendant 4 heures minimum.

Date: 14-3-08 Heure Début: 11:05 Heure Fin: 11:15 Sceau:



Curing Début: 10:35 Curing Fin: 4:15

33.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE PIÈCE DART

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ".



Date: 17-03-08

Heure Début: 8:00

Heure Fin: 8:05 Sceau:



34.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TRIMAGE COMPOSITES DART

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2445.

Date: 17-3-08 Heure Début: 2:05 Heure Fin: 2:35 Sceau:



Date: Mercredi, 2008-01-23 16:17:30

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

35.0	AAC0062	Label N° D0588-041
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Label N° D0588-041

36.0	AAC0444	Surface Veil
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Commentair Qty.: 0.07 VERGE CAR(s)/Unit Total : 0.07 VERGE CAR(s)  
Surface Veil

37.0	AAC0501	Résine Mia-Poxy
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Commentair Qty.: 0.007 GALLON(s)/Unit Total : 0.007 GALLON(s)  
Résine Mia-Poxy

38.0	AAC0502	Durcisseur 95 Pour Résine Mia-Poxy
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Commentair Qty.: 0.007 PINTE(s)/Unit Total : 0.007 PINTE(s)  
Durcisseur 95 Pour Résine Mia-Poxy

39.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FABRICATION GÉNÉRALE DART

Coller le abel N° D0588-041 selon les séquences suivantes:

- 1- Surface Veil
- 2- Label
- 3- Surface Veil

Laisser scher pendant 4 heures.

Date: 19/03/08 Heure Début: 9:00 Heure Fin: 2:30 Sceau:

40.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens
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Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.025 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6284-1

41.0	AC0059	Durcisseur Polysoft #004009 Sikkens
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Commentair Qty.: 0.020 UNITE(s)/Unit Total : 0.020 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

42.0	FINITION 3	FINITION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION PIÈCE DART

Faire les réparation de finition s'il y a lieu à l'aide du Sikkens.

Date: 18-3-08 Heure Début: 11:20 Heure Fin: 11:30 Sceau:

Date: Mercredi, 2008-01-23 16:17:30

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: AFT BAGGAGE DOOR D2445

Numéro Job: 42579

Numéro Article: DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

43.0 AAC0683 Dupont Primer N° 7704S

Commentaire Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-6433-2

1-6440-1 MAR 20 2008

44.0 AAC0685 Dupont Activator - Reducer Chromabase N° 7775S

Commentaire Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

Dupont Activator - Reducer Chromabase N° 7775S

1-6433-1

45.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

Préparation du matériel

Nettoyage qty 1 MAR 19 2008

Nettoyage qty 1 MAR 20 2008



Bien brasser les contenants servant à faire le mélange du primer gris N° 7704S et ensuite faire le mélange selon les directives suivantes:

Inscrire la température ambiante.

Température: 68 °F

60° - 70°F Chromabase 7765S Acticator-Reducer N° de Lot: \_\_\_\_\_

70° - 80°F Chromabase 7775S Acticator-Reducer N° de Lot: 1-6433-1

80° - 90°F Chromabase 7785S Acticator-Reducer N° de Lot: \_\_\_\_\_

90° - 100°F Chromabase 7795S Acticator-Reducer N° de Lot: \_\_\_\_\_

MAR 20 2008

Date: MAR 19 2008 Sceau:



46.0 PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs

PEINTURE / PRIMER DART

Appliquer deux couches de primer Dupont N° 7704S selon les instructions du fabricant, en prenant bien soin de faire un léger sablage entre les deux couches à l'aide de papier sablé grit 220.

MAR 20 2008

Date: MAR 19 2008

Heure Début: \_\_\_\_\_

Heure Fin: \_\_\_\_\_

Sceau:



47.0 INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

INSPECTION PIÈCE DART

Faire l'inspection selon le dessin N° D2445.

Date: Mercredi, 2008-01-23 16:17:30  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 42579

Nom Dessin: AFT BAGGAGE DOOR D2445  
Numéro Article: DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: 25 MAR 08 Heure Début: 9H30 Heure Fin: 10H00 Sceau: 01-13

48.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage des pièces.

Quantité: 1

Date: 25-03-08

Sceau: 11



Quantité:

Date:

Sceau: